

Work Order ID 154541

Thursday, December 15, 2016 8:01:03 AM

154541

Page 1

Item ID: D3295-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Replacement Interior Window for -111
Start Date: 12/9/2016 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 12/15/2016 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: DAS 21 9-29 Date: DEC 15 2016 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3295	E								

100

0.00

100

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

0.03

***ENSURE PLASTIC BLOCK ARE ON TABLE BEFORE CUTTING
PARTS***

1-Cut D3295-1 as per Dwg D3295

Dwg Rev: EProg Rev: E

2-Remove plastic, clean and wrap in saran wrap.

3-Deburr if necessary

(2)

Dec 17/01/06

110

0.00

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

(2)

Dec 17/01/06

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Page 2

NR2

Quality Control

DAS
36
9-89
JAN 11 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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Work Order ID 154541

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Item ID: D3295-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Replacement Interior Window for -111
Start Date: 12/9/2016 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 12/15/2016 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>SH36</u>	0.00							
150									
Packaging	Memo	0.00				<u>2</u>	<u>6</u> ^{DAS}		
Packaging							<u>1-89</u>		JAN 13 2017
160	QC21- Final Inspection - Work Order Release	0.00							JAN 16 2017
160									
QC	Memo	0.03							
Quality Control									<u>ME</u> 17-1-13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
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Past Expiry Date	☐	Manufacturing Process	OTHER : _____							
Misidentified	☐	Past Due								

Picklist Print

Thursday, December 15, 2016 8:01:03 AM

Page 1

Work Order ID: 154541

154541

Parent Item: D3295-041

D3295-041

Parent Item Name: Replacement Interior Window for -111

Start Date: 12/9/2016

Required Date: 12/15/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP C05.06.20D3295-1 no longer made in-houseKJ/JLM
IPP Rev:D Added DT8822 07-03-20 JLM
IPP Rev:E Returned Manufacturing In House 07-06-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2728-1		Manufactured	Yes			140	Each	-7.0000	1	2			
D2728-1									**			17/01/11	
Dart Logo Label Small													
MLEXS.125-9034-01		Purchased	No			100	sf	72.2200	1.24	2.610526			
MI FXS 125-9034-01									**			m 17/01/06	
1/8" 9034 Lexan Sheet (Clear)													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						MAT019	40.22						
						m135241	40.22						
						therm	32						
						m135485	32						

DAS
36
9-89

2.8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Substation ☐	Process Improvement ☐																																																												
Past Expiry Date ☐	Manufacturing Process ☐																																																												
Misidentified ☐	Past Due ☐																																																												
Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐																																																											
Bending ☐	Set-up ☐	Folio/Program ☐																																																											
Centre Not Concentric ☐	BOM/Route ☐	Grain ☐																																																											
Cracks ☐	Broken/Damage/Defect ☐	Weld ☐																																																											
Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐																																																											
Cuffs ☐	Contamination ☐	Out of Sequence ☐																																																											
Crushing ☐	Countersink ☐	Off-set ☐																																																											
Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐																																																											
Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐																																																											
Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐																																																											
		OTHER : ☐																																																											

DART AEROSPACE LTD		Work Order:	15454
Description: Window		Part Number:	D3295
Inspection Dwg: D3295 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.156	+0.005/-0.001	0.159	1		V=0.02	
17.13	+/-0.030	17.13	1		Tape	
10.43	+/-0.030	10.43	1		V=0.01	
14.35	+/-0.030	14.35	1			
8.98	+/-0.030	8.98	1			
0.625	+/-0.010	0.624	1			
7.109	+/-0.010	7.109	1			
15.845	+/-0.010	15.845	1			
2.308	+/-0.010	2.309	1			
5.420	+/-0.010	5.421	1			
9.402	+/-0.010	9.405	1			
1.312	+/-0.010	1.313	1			
6.260	+/-0.010	6.261	1			
12.520	+/-0.010	12.520	1			
0.313	+/-0.010	0.318	1			
3.750	+/-0.010	3.750	1			
8.150	+/-0.010	8.150	1			
9.006	+/-0.010	9.005	1			
0.125	+/-0.010	0.119	1			

Measured by:	<i>DM</i>	Audited by:	DAS 38 8-86	Preliminary Approval:	
Date:	17/01/06	Date:	JAN 10 2017	Date:	

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue P/O D3295-041	KJ/EC/DD	
B	13.02.27	Dwg Rev updated	KJ	

ITEM	QTY -041	QTY -041B	P/N	DESCRIPTION
	X		D3295-041	FLOOR WINDOW
		X	D3295-041B	FLOOR WINDOW, BLANK
1	1		D3295-1	WINDOW
2		1	D3295-1B	WINDOW, BLANK
3	1	1	D2728-1	DECAL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 154541 u19
16-12-15

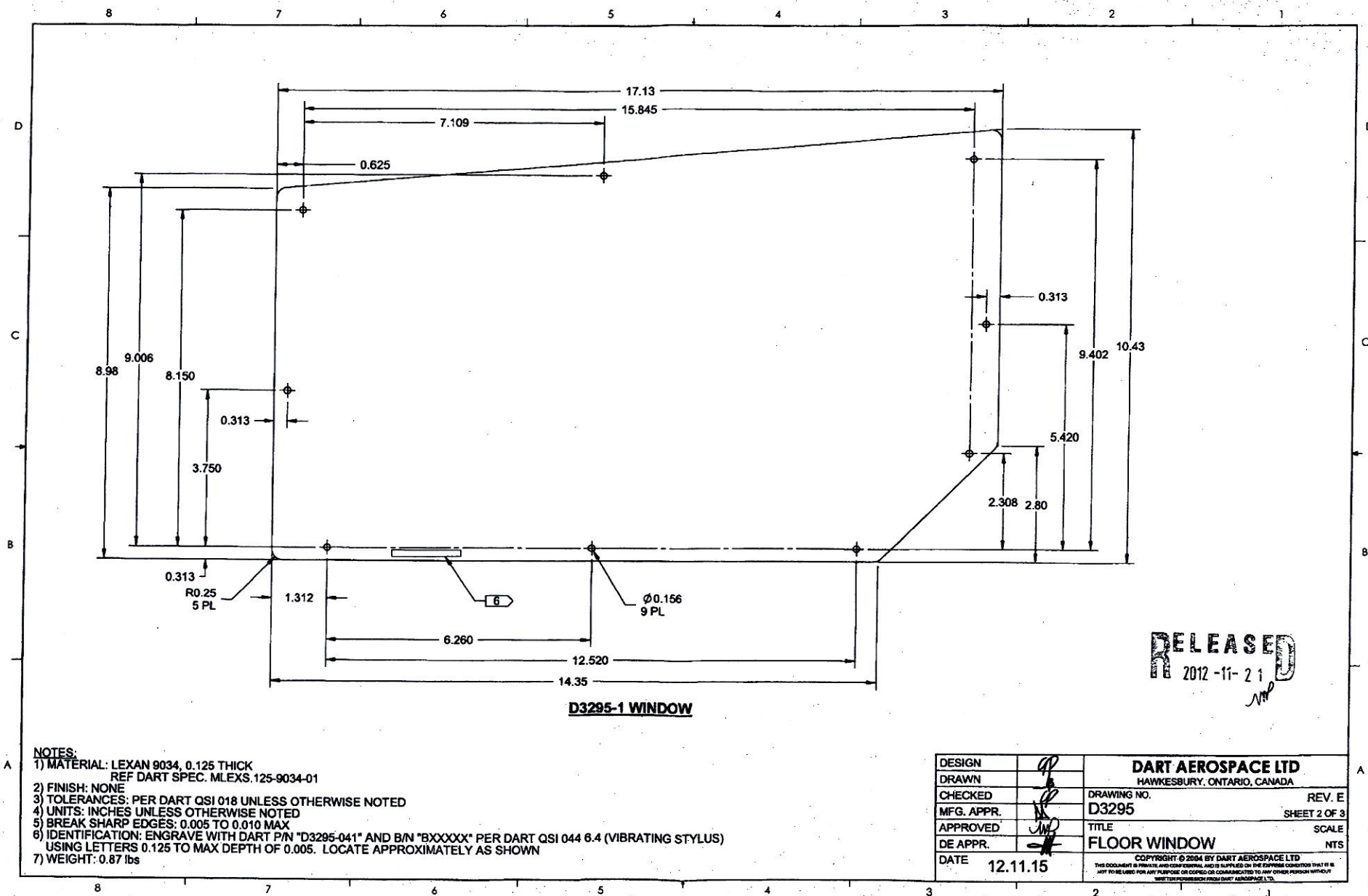
RELEASED
2012-11-21

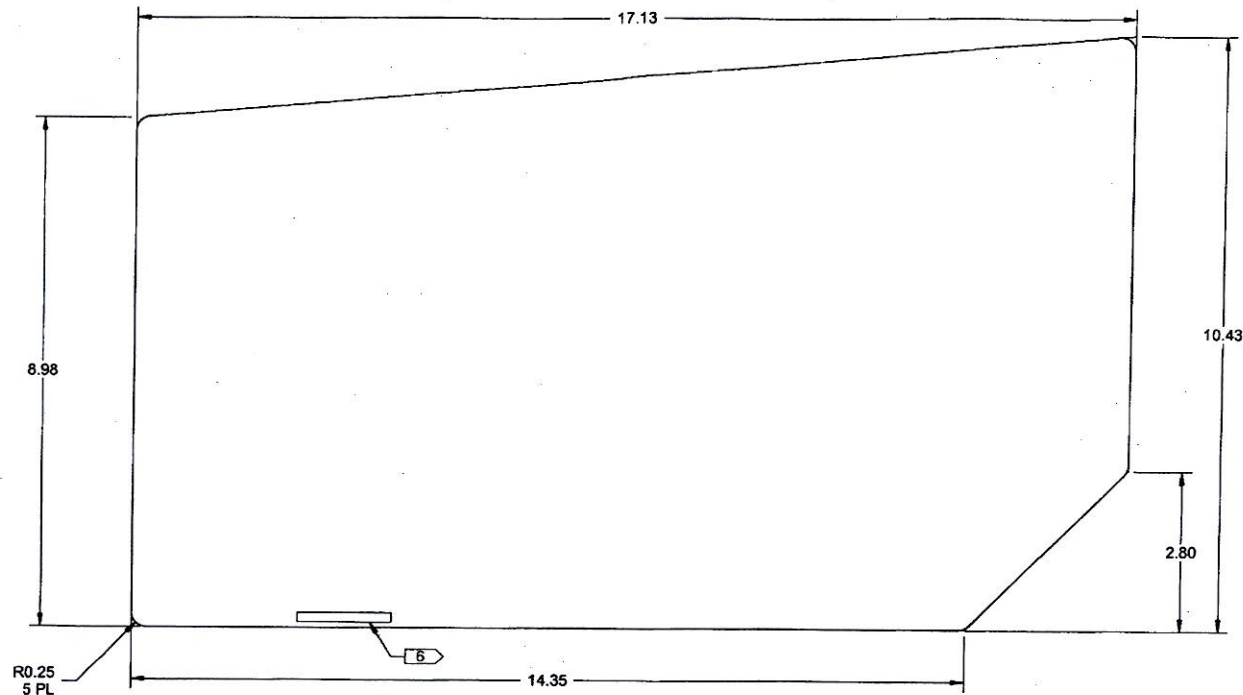
E	ADD D3295-041B-1B. REF. PAR12-223.	MB	12.11.15
D	REVISE MATERIAL TO LEXAN 9034 FROM POLYCAST ACRYLIC SHEET. ZONE A8 SH 2 ADD MISSING DIMENSION PER NCR 247. ZONE C3 SH 2 REFORMAT DRAWING	MP	07.11.07
C	CHANGE TEMPLATE # TO DT8822	SSH	07.02.21
B	UPDATE MATERIAL PER NCR 029	CP	06.04.13
A	NEW ISSUE	CP	04.06.28
REV.	DESCRIPTION	BY	DATE
DESIGN	99	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3295 TITLE FLOOR WINDOW REV. E SHEET 1 OF 3 SCALE NTS COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	99		
CHECKED	99		
MFG. APPR.	99		
APPROVED	99		
DE APPR.	99		
DATE	12.11.15		

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) N/A
 - 6) ENSURE SURFACE IS FREE OF DIRT/GREASE PRIOR TO APPLICATION OF SELF-ADHESIVE DECAL
 - 7) WEIGHT: D3295-041/-041B = 0.87 lbs

D3295-041 FLOOR WINDOW

D3295-041B FLOOR WINDOW, BLANK





E D3295-1B WINDOW

RELEASED
2012-11-21
JMP

NOTES:

- 1) MATERIAL: LEXAN 9034, 0.125 THICK
REF DART SPEC. MLEXS.125-9034-01
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D3295-041B" AND B/N "BXXXXX" PER DART QSI 044 6.4 (VIBRATING STYLUS)
USING LETTERS 0.125 TO MAX DEPTH OF 0.005. LOCATE APPROXIMATELY AS SHOWN
- 7) WEIGHT: 0.87 lbs

DESIGN	GP	DART AEROSPACE LTD	
DRAWN	GP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	GP	DRAWING NO.	REV. E
MFG. APPR.	GP	D3295	SHEET 3 OF 3
APPROVED	JMP	TITLE	SCALE
DE APPR.	JMP	FLOOR WINDOW	NTS
DATE	12.11.15	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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